

## Work Order ID 72144

Tuesday, July 19, 2011 1:45:00 PM

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Page 1

Item ID:

D3537-3

Accept



Setup Start



**Revision ID:** 

Item Name:

Required Date: 7/25/2011

Wearpad

7/19/2011

**Start Oty: 10.00** Req'd Qty: 10.00

**Cust Item ID: Customer:** 

Reference:

**Start Date:** 

**Approvals:** 

**Process Plan:** 

QC:

Date: //

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop

Sequence ID/ Work Center ID Operation Description Set Up/

**Run Hours** 

Tool ID

Tool # Plan Code

Accept Qty

Reject **Qty** 

Reject Insp. Number Stamp

Draw Nbr

**Revision Nbr** 

D3537 Rev C

100

Waterjet

FLOW CNC Waterjet 364.663

FLOW WATER JET

Memo

1-Cut as per Dwg D3537 □Dwg Rev: ☐ □Prog Rev: ☐ □2-

0.00

0.00

Deburr if necessary

110

QC Quality Control QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B11-8-4

B11-8-4

120

QC

0.00

D 1105/05

Memo

QC8- Inspect parts - second check

0.00

Quality Control

Dart Ae	rospace	Ltd						
W/O:			W	ORK ORDER CHANGE	:S			,
DATE	STEP	PRO	CEDURE CHA		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	) <b>:</b>	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA:	Date: _	
	Re	esolution:	Disposition	on:	QA: N/C Clo	sed:	Date: _	<del>,</del>
NCR:		V	VORK ORD	ER NON-CONFORMA	NCE (NCR	)		
DATE	OTED	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Item ID:

D3537-3

Accept

Setup Start

Stop



**Revision ID:** 

**Item Name:** 

Wearpad

7/19/2011

**Start Qty: 10.00** 

Req'd Qty: 10.00



Date:

**Cust Item ID: Customer:** 

Reference:

**Start Date:** 

A	pprovals:	
	DDI OVAIS.	

Process Plan:

Date:

**Tooling:** SPC (Y/N):

0.00

0.00

Date:

Date:

Run Start

Stop

Required Date: 7/25/2011

Sequence ID/ **Work Center ID** 

130

Brake NC

Operation **Description** 

NC BRAKE

Set Up/ **Run Hours** 

Tool ID

Tool # Plan Code Accept Qty

Reject **Qty** 

Reject Insp. Number Stamp

Brake NC

Deburr if necessary Form on Brake as per Dwg D3537using Jigs DT8261 and DT8326.Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158

Memo

140

Quality Control

QC5- Inspect part completeness to step on W/O

Ensure joggle as per dwg D3429

0.00

0.00

Sulsely

150

Large Fab

Large Fab

Memo

0.00

0.00

Large Fab

2059B Hardcoat

X14 11-08-31 186/EL

Description Batch□A/R
□ Weld hardcoat as per Dwg D3437

<b>Dart Aerospace Ltd</b>	<b>Dart</b>	<b>Aeros</b>	pace	Ltd
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Dart Ae	rospace	Ltd		•						
W/O:			W	ORK ORDER CH	ANGES					
DATE	STEP	PROC	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		Description of NC		<b>Corrective Action</b>	Section B		Verifica	ation	Approval	Approval
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Page 3

Item ID:

D3537-3

Accept

Setup Start

Stop



**Revision ID:** 

Wearpad Item Name:

**Required Date:** 7/25/2011

7/19/2011

Start Qty: 10.00

**Operation** 

Description

Req'd Qty: 10.00



**Cust Item ID: Customer:** 

Reference:

Start Date:

Approvals:

Process Plan:

Date:

QC10- Inspect visual per QSI004- ground welds

**Tooling:** 

Date:

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

**Work Center ID** 

160

QC

Quality Control

Memo

Set Up/ **Run Hours** 

**Tool ID** 

Tool # Plan Code

Accept **Qty** 

Reject Qty

Run

Reject Insp. Number Stamp

0.00

ulos/31

170 QC

Quality Control

Memo

QC5- Inspect part completeness to step on W/O

0.00

Dulco/11

180

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

14X & m & 11/04/01

M117332

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		Description of NC	Corrective Action Section B			Verification Ap		Approval	Approval		
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Item ID:

D3537-3

Accept

Setup Start

**Revision ID:** 

Item Name:

Wearpad

**Start Date:** 7/19/2011

Required Date: 7/25/2011

**Start Qty: 10.00** 

Req'd Qty: 10.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

**Tooling:** 

Date:

Run

Start

Stop



QC:

Date:

SPC (Y/N):

0.00

0.00

**Run Hours** 

Date:

Stop

Sequence ID/ **Work Center ID** 

190

QC

Quality Control

Operation **Description** 

QC3- Inspect Part Finish

Memo

Tool ID Set Up/

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

200 Identify as per dwg & Stock Location:



Packaging Packaging

Memo

0.00

210

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dan Aerospace Liu	art Aerospace	e Ltd
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W/O:			WC	ORK ORDER CHANGES	<b>)</b>						
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Part No	•	PAR #:	Fault Cate	gory: l	NCR: Yes	No DQ	<b>4</b> :	Date:			
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NCR:		,	WORK ORD	ER NON-CONFORMAN	CE (NCI	₹)					
DATE	E STEP Description of NC				Section B  on Sign & Section			Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng	Date		on C	Chief Eng	QC Inspector		
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## **Picklist Print**

Tuesday, July 19, 2011 1:45:06 PM

Work Order ID: 72144

D3537-3

Parent Item Name: Wearpad



Start Date: 7/19/2011

Required Date: 7/25/2011

Page 1

**Start Qty: 10.00** 

Required Qty: 10.00

**Comments:** 

Parent Item:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA	11  11   <b> 11  </b>	Purchased	No			100	sf	222.7000	0.149	1.568421	1B(1-8	- <i>Ly</i>	
				Location	÷	Loc	Qty	Loc Code				ſ.	

Location	Loc Qty	Loc Code	
MAT020	22.7		
117275	1.7		
117653	21		
MAT021	200		
118217	200		118217

				•					2 · 3
W/O:			W	ORK ORDER CHANG	ES				<u>+</u>
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Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	<b>A</b> :	Date: _	
Resolution:			Disposition: QA			QA: N/C Closed:			
NCR:			WORK ORE	ER NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC	Corrective Action Section Initial Action Description		on B Sign &	Verific		Approval	Approval
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DART AEROSPACE LTD	Work Order:	72144
Description: Wearpad	Part Number:	D3537-3
Inspection Dwg: D3537 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST									
		First Arti	icle	Prot	otype				
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments		
5.859	+/-0.010	5.863	P		V B62				
3.500	+/-0.010	3,499	*		V				
1.965	+/-0.010	1.961	K		ν	_			
2.795	+/-0.010	7.794	*		ν	-			
3.625	+/-0.010	3.619	4		γ				
0.220 x 0.380	+/-0.010	. 293 X 386	7		V				
	<u> </u>								
	B	Audited by:			Prototype A	pproval:	N/A		
Date:	11-8-4	Date:	Date: Worklos			Date: N/A			
David Bata	01								

Rev	Date	Change	Revised by Approved
Α	07.05.10	New Issue	 KJ/JLM of B

## **Dart Aerospace Ltd**

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	R	esolution:	ution: Disposition:				Date: _	_ Date:	
NCR:			WORK ORE	ER NON-CONFORMA	ANCE (NCR	)			
DATE	STEP	Description of NC		Corrective Action Secti		Verification	Approval	Approval QC Inspector	
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng		
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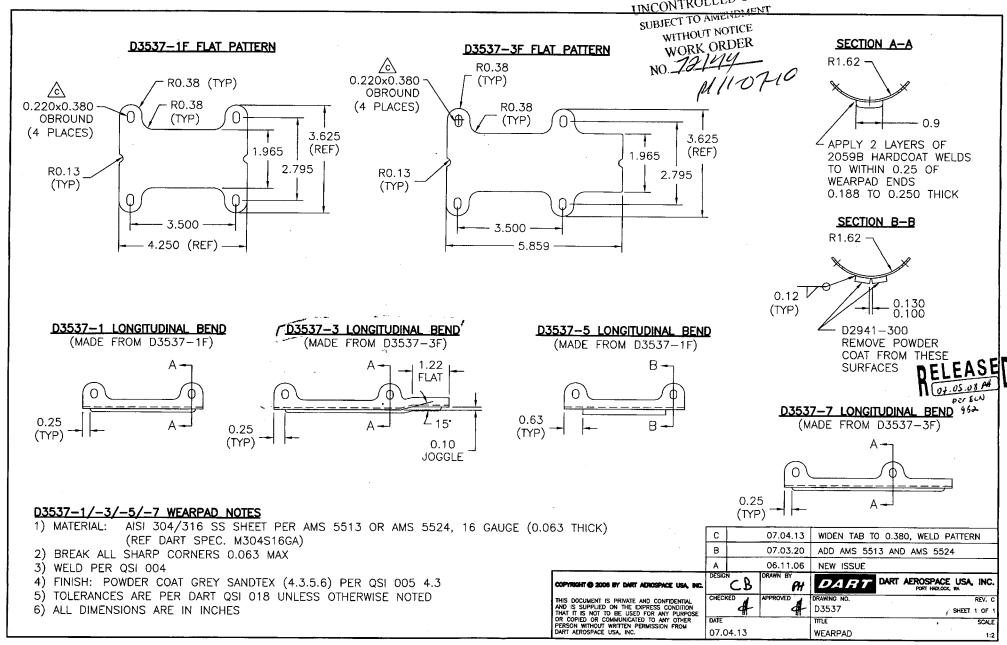
NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

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## **Dart Aerospace Ltd**

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W/O:			W	ORK ORDER CHANG	BES					
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